	Work Order ID 64450 Monday, December 06, 2010 10:20:41 AM										Page
Item ID: Revision ID:	D3953-9			Accept				s	Setup Sta	rt	
	Gas Spring Wa	sher							Sto	p	
Start Date: Required Date: Reference:	12/6/2010 12/13/2010	Start Qty: 12.00 Req'd Qty: 12.00	1 190101 11010 1101 1001		Cust Ite Custom					1100111001	
Approvals:	Process Plan	n: MF	Date: 0-12-06	Tooling:		Date:		R	Run Sta	rt	
	QC:		Date:	SPC (Y/N):		Date:			Sto	p	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool I	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr								 	············
D3953	С										
				0.00				16	6		
Hardinge Hardinge CNC Lathe	Small	Memo TURN AS FOLIO RI DWG RE DEBURR	V:		20<						

110

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

Quality Control

st ration

Dart Aerospace Ltd

	-								
W/O:			W	ORK ORDER CHAN	GES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Table to the state of the state
<u> </u>			· · · · · · · · · · · · · · · · · · ·						
· · · · · · · · · · · · · · · · · · ·								1	
Part No		PAR #:							
	Res	solution:						Date: _	
NCR:		•	WORK ORD	ER NON-CONFORM	MANCE (NO	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da	Sign & Section C		Chief Eng	QC Inspector
								<u> </u>	
-		V-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1							

NOTE: Date & initial all entries

Work Order ID 64450

Monday, December 06, 2010 10:20:41 AM



Page 2

Item ID:

D3953-9

Accept

Setup Start



Revisior **ID**:

Item Name:

Gas Spring Washer

Start Date: 12/6/2010

Start Qty: 12.00

Req'd Qty: 12.00 **Required Date: 12/13/2010**

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date: ____

Start Run

Stop

Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description,

QC: ____

QC8- Inspect parts - second check

Memo

Set Up/ **Run Hours**

0.00

onle wholished

Tool ID

Tool # Plan Code

Accept Qty

Reject Reject Qty Number

Insp. Stamp

130

Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 10/12/13 -mF 10-12-13

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES		-			
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								ļ t		
Part No	•	PAR #:	Fault Cate	gory:	NCR: Y	'es N	o DQ .	A:	_ Date: _	
	R	esolution:	QA: N/	C Clos	sed:		Date:			
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	ICR)	_			
DATE	STEP	Description of NC	Corrective Action Section				Verification		Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Section		ction C Chief Eng		QC Inspector
							<u> </u>			
					Î					

NOTE: Date & initial all entries

Picklist Print

Monday, December 06, 2010 10:20:45 AM

Work Order ID: 64450

Parent Item: D3953-9

Parent Iten. Name: Gas Spring Washer

Start Date: 12/6/2010

Required Date: 12/13/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP RevA: New issue 09.10.13 DD verified by:EC as per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR0.750 Delrin Round Bar 0.75"	1011 II 001 IIIII (011 011 0	Purchased	No			100	f	105.8870	0.05	0.631579	10	112/0	
				Location		Loc	<u>Otv</u>	Loc Code					

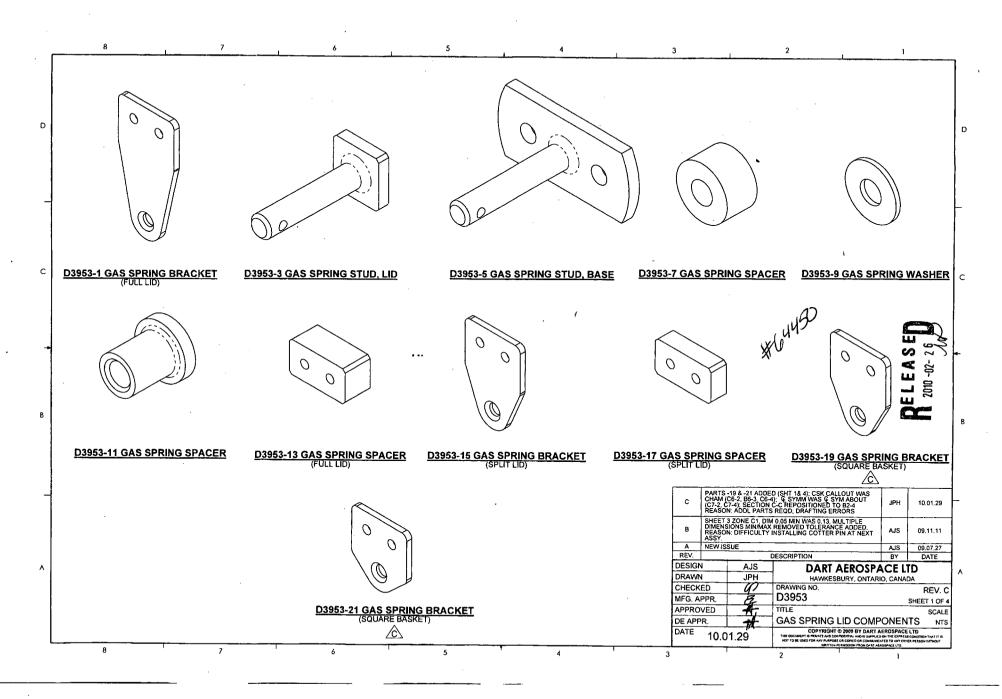
Location	Loc Qty	Loc Code	
MAT	,49.35,		
116183	49.35		
MAT050	56.537		
112418	0.12		· A
115472	56.417		.5 PL

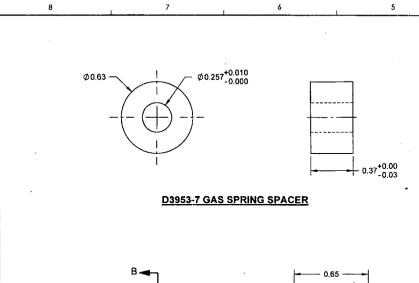
Page 1

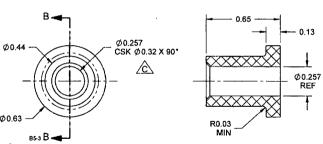
Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
	Res	solution:	n: Disposition: QA: N/C Clo						
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (NCR	3)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	tion C Chief Eng		QC Inspector
								<u> </u>	
							· · · · · ·		
									3
			1			1			

NOTE: Date & initial all entries

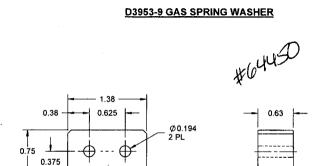






D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

0.06 X 45° CHAM

TYP

0.05+0.03

C

DESIGN	AJS	DART AEROSPACE LTD				
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA				
CHECKED	(P)	DRAWING NO.	EV: C			
MFG. APPR.	E	D3953 SHEET	3 OF 4			
APPROVED	-	TITLE	SCALE			
DE APPR.	#	GAS SPRING LID COMPONENTS	NTS			
DATE 10.0	1.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THE DOCUMENT IS PRIVATE AND CHRIDISTITU. AND IS SUPPLED ON THE EXPRESS CONDITION THAT IT IS MOT TO BE USED FOR ANY PURPOSE OR COPPLED IN COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTER PERSONS IN FROM DATE ARROPMENT. TO.				

NOTES: 1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR REF DART SPEC M304B

Ø0.63

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

Ø0.63

Ø0.257^{+0.010}

DART AEROSPACE LTD	Work Order:	64450
Description: Gas Spring Washer	Part Number:	D3953-9
Inspection Dwg: D3953 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.63	+/-0.030	0.630	/		4014	201-3
Ø0.257	+0.010/-0.001	0,260	/			_\
0.05	+0.030/-0.000	0300				
						_
·						

Measured by:	13		Audited by:	and	Prototype Approval:	N/A
Date:	10/1	2/09	Date:	10/12/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	09.10.22	New Issue	KJ 🔥	11
В	09.12.14	Dimension updated per Dwg Rev	KJ 😽	
L				_/ /